

Work Order ID 91399

91399

Tuesday, October 09, 2012 4:07:44 PM

Ship Friday Page 1

Item ID: D350-636-047

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Training Wearplates Installation, LH/RH

Stop *NS2*

Start Date: 10/9/2012 Start Qty: 8.00

Cust Item ID:

Required Date: 10/18/2012 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: mf Date: 12-10-9 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D350-636	1

100 0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-636-047 CHG005

110 0.00

110

Pick Kit

Packaging

Memo

0.00

Packaging

115 0.00

QC4- 100% Inspect kits for completeness

115

QC

Memo

0.00

Quality Control

8 (DAS 05 12-10-24)
12-10-16

12/10/16 (8)

8 (DAS 05 12-10-24)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input checked="" type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

Work Order ID 91399***91399***

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Tuesday, October 09, 2012 4:07:44 PM

Item ID: D350-636-047

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Training Wearplates Installation, LH/RH

Stop ***NS2***Start Date: 10/9/2012 Start Qty: 8.00 ***8***

Cust Item ID:

Required Date: 10/18/2012 Req'd Qty: 8.00 ***8***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

0.00

120

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-636-047

Location: _____

PPP Rev: E

8

10/10/25 sf

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/10/25

W12.10.25

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data <input type="checkbox"/>												
Equip/Tooling <input type="checkbox"/>												
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Material <input type="checkbox"/>												
Setup <input type="checkbox"/>												
Other <input type="checkbox"/>												
Process <input type="checkbox"/>												
Supplier <input type="checkbox"/>												
Training <input type="checkbox"/>												
Unapproved <input type="checkbox"/>												
FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <hr/> <hr/> <hr/>		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other <hr/> <hr/> <hr/>	

Picklist Print

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Work Order ID: 91399

Parent Item: D350-636-047

Parent Item Name: Training Wearplates Installation, LH/RH

Start Date: 10/9/2012

Required Date: 10/18/2012

Start Qty: 8.00 / 0

Required Qty: 8.00

Comments: IPP REV:A 10.09.27 NEW ISSUE DD VERF:EC IPP Rev:B 11.04.14 ecn11-553
DD verf:EC IPP REV:C AS PER ECN 11-603 JLM 11.07.07 VERIFIED BY:DD
IPP Rev:D 112.04.16 AS PER ECN 12-542 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4154.041 Wearplate Assembly		Manufactured	No			110	Each	2.0000	1	8	90372	245	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FPI		2					90373	64	
				90298		2					90373	24	SMD
AN3C36A BOLT		Purchased	No			110	Each	172.0000	4	3240			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		24							
				101261		4							
				122204		20							
				ST353		148							
				116590		0							
				119083		1							
				119324		3							
				121276		4							
				121388		5							
				121689		50							
				122204		67							
				122491		14							
				15924		4							

121276 44
121388 50-1
121689-34
122204 284-4

SMD

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Work Order ID: 91399

Parent Item: D350-636-047

Parent Item Name: Training Wearplates Installation, LH/RH

Start Date: 10/9/2012

Required Date: 10/18/2012

Start Qty: 8.00

Required Qty: 8.00

AN3G37A

BOLT

Purchased No

110 Each 143.0000

1

8/18

Location

Loc Qty

Loc Code

ST324	50	
122204	50	
ST353	76	
122491	50	
122843	26	
ST354	17	
116874	11	
117010	2	
120422	3	
121584	1	

122204 (-2)

Smb

AN3G42A

BOLT

Purchased No

110 Each 83.0000

1

8/10

Location

Loc Qty

Loc Code

FG	5	
121103	5	
ST354	78	
106176	1	
120464	1	
122241	46	
122843	30	

122241 (-2)

Smb

NAS1149G0363R

Washer

Purchased No

110 Each 4,556.0000

10

80/15

Location

Loc Qty

Loc Code

297	2000	
122441	2000	
ST297	2556	
114742	2356	
122063	200	

114742 (-20)

Smb

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Work Order ID: 91399

Parent Item: D350-636-047

Start Date: 10/9/2012

Required Date: 10/18/2012

Parent Item Name: Training Wearplates Installation, LH/RH

Start Qty: 8.00/0

Required Qty: 8.00

MS21043-3

Nut

Purchased No

110 Each 583.0000 5

40.50 -10

Location Loc Qty Loc Code

FG 72

103691 72

ST301 124

118077 2

118614 7

118686 30

119758 20

121255 20

121708 45

ST315 387

122993 387

122993

Manufactured No

110 Each 738.0000 8

64.80 90492 -16

Location Loc Qty Loc Code

ST057 6

79561 6

ST067 688

64760 1

68247 4

73829 19

73830 2

76791 17

79560 20

90492 625

ST069 44

87185 44

Manufactured No

110 Each 3.0000 1

1.08 90492

Location Loc Qty Loc Code

ST104 3

82385 3

91603

SMB

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Work Order ID: 91399

Parent Item: D350-636-047

Parent Item Name: Training Wearplates Installation, LH/RH

Start Date: 10/9/2012

Required Date: 10/18/2012

Start Qty: 8.00

Required Qty: 8.00

D4170-3 Bushing Manufactured No

Each 20.0000

Location

Loc Qty

Loc Code

ST101	12	
88531	12	
ST104	8	
79593	4	
87647	4	

110 Each 22.0000

Location

Loc Qty

Loc Code

ST353	22	
116075	4	
117514	18	

D4170-3
Bushing

AN3C34A
BOLT

88531 1208

79593 44

87647 44

117514

9153416

Smrs

Smrs

DART AEROSPACE USA, INC.

IIN-D350-636

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(CONTINUED FROM PREVIOUS PAGE)

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -047	Part Number	Description
***43	2	2	2	2		D3493-1	WASHER
*90	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
*91A	4	4	4	4	4	AN3C36A	BOLT
91B	1	1	1	1	1	AN3C37A	BOLT
91C	1	1	1	1	1	AN3C42A	BOLT
*92	7	7	7	7	8	AN960C10	WASHER (OR NAS1149CO363R)
92A			1	1		AN960C10	WASHER (OR NAS1149CO363R) ³
*93	4	4	4	4	4	MS21043-3	NUT
*94	7	7	7	7	8	D3873-1	BUSHING
94A			1	1		D3873-1	BUSHING ³
*95	1	1	1	1	1	D4171-1	BUSHING ⁴
96					4	D4170-3	SPACER
*97	1	1	1	1	1	AN3C34A	BOLT
*98	2	2	2	2	2	AN960C10	WASHER (OR NAS1149CO363R)
*99	1	1	1	1	1	MS21043-3	NUT

* PART OF D4168-041/-042/-043/-044

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING AN APICAL FLOAT SYSTEM

¹ QTY USED MAY BE LESS ON SKIDTUBES WITH APICAL CYLINDRICAL OR TRI-BAG FLOATS

² HARDWARE USED ON THE SKIDTUBES INSTALLED WITH APICAL CYLINDRICAL BAG FLOATS

³ HARDWARE USED ON THE SKIDTUBES INSTALLED WITH APICAL TRI-BAG FLOATS

⁴ HARDWARE NOT USED ON THE SKIDTUBES INSTALLED WITH APICAL TRI-BAG FLOATS

8.0 PARTS LIST (D350-636-015/-016/-017/-018/-047 KITS)

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -047	Part Number	Description
	X					D350-636-015	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE W/ TRAINING WEARPLATE
		X				D350-636-016	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE W/ TRAINING WEARPLATE
			X			D350-636-017	SKIDTUBE INSTALLATION, LH AIRCRAISER/ APICAL TRI-BAG FLOAT COMPATIBLE W/ TRAINING WEARPLATE
				X		D350-636-018	SKIDTUBE INSTALLATION, RH AIRCRAISER/ APICAL TRI-BAG FLOAT COMPATIBLE W/ TRAINING WEARPLATE
					X	D350-636-047	TRAINING WEARPLATE KIT (LH/RH)
1	1					D4168-041	SKIDTUBE ASSEMBLY, LH
1		1				D4168-042	SKIDTUBE ASSEMBLY, RH
1			1			D4168-043	SKIDTUBE ASSEMBLY, LH
1				1		D4168-044	SKIDTUBE ASSEMBLY, RH
*1	1					D4168-1	SKIDTUBE WELDMENT, LH
*1		1				D4168-2	SKIDTUBE WELDMENT, RH
*1			1			D4168-3	SKIDTUBE WELDMENT, LH
*1				1		D4168-4	SKIDTUBE WELDMENT, RH
**2	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8		22541N120	NUT
*5	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1		AN960C816L	WASHER (OR NAS1149CO832R)
*7	1	1	1	1		MS21083C8	NUT
*8	1		1			D3488-041	BLADE FITTING, LH
*8		1		1		D3488-042	BLADE FITTING, RH
9	1	1	1	1		D2741	BLADE
10	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2		AN960JD816	WASHER (OR NAS1149CO863J)
12	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8		D2745	BUSHING
*16	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4		AN960C10L	WASHER (OR NAS1149CO332R)
*20B	4	4	4	4		NAS1515H3L	WASHER
*30	8	8	8	8		D3492-041	PLUG ASSEMBLY
*31	8	8				D3492-043	PLUG ASSEMBLY
*32			8	8		D3492-045	PLUG ASSEMBLY

(CONTINUED ON NEXT PAGE)